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D350-567-145
Job Sheet 200281



Part No: D350-567-145

Job Qty: 1 pcs

Part Name: Floor Window Close Out (AS350 B3e)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 18945

Note: DSI9590 REV.G IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		10/14/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: 8233217



Part: D350-567-145

Job No: 200281

Serial No/Batch: 8233217

Revision: G

Inspector:

Exp Date:

Instructions: TC STC SH92-18 Issue 5, FAA STC SH989NE

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				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120 QC 4	1 pcs	10/14/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
130 Packaging 3-1 - Stock - B4B 1 pcs		10/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	10/14/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
140 QC 21 - FG	1 pcs	10/14/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	
Part Op 110 - Pick Kit					
Descriptions: 120 - QC4- 100% Inspect kits for completeness					
130 - Identify and pack for shipping as per PPP D350-567-145 Location:FG033					
135 - Document Control - Photocopy bluefile & type labels per PPP D350-567-145 CHG001					
140 - QC21- Final Inspection - Work Order Release					

PK6

(012714)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea) ✓	110-Packaging 1 - Pick Kit	5198195 ✓
AN525-10R6	Screw	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5179192 ✓
AN525-832R7	Screw	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5158306 ✓
CB200 3-18-2020	Acrylic Adhesive, 3.5G	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5142389 ✓
D3802-1	Window Seal (\$ Per Foot)	2 ft (2 ea) ✓	110-Packaging 1 - Pick Kit	5225240 ✓
D4435-9	Bracket	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5212414 ✓
D4436-041	Aft Bracket Assembly	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5230119 ✓
D4441-1	Rubber Seal	2 ft (2 ea) ✓	110-Packaging 1 - Pick Kit	5092167 ✓
D4730-020-030	Velcro Strip 2.0W/ X 3.0L	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5145071 ✓
D4971-041	T/R Bellcrank Cover Assembly	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5204510 ✓
D5076-041	Fwd Bracket Assembly	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5156136 ✓
MS21042L06	Nut	7 Ea (7 ea) ✓	110-Packaging 1 - Pick Kit	5219477 ✓
MS21042L08	Nut	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5134763 ✓
MS21042L3	Nut	5 Ea (5 ea) ✓	110-Packaging 1 - Pick Kit	5204285 ✓
MS21059L3	Nut Plate	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5225756 ✓
MS35206-229	Screw	7 Ea (7 ea) ✓	110-Packaging 1 - Pick Kit	5143702 ✓
NAS1149F0332P	Washer (AN960-10L)	10 Ea (10 ea) ✓	110-Packaging 1 - Pick Kit	5225418 ✓
NAS1149FN616P	Washer (AN960-6L)	14 Ea (14 ea) ✓	110-Packaging 1 - Pick Kit	5144757 ✓
NAS1149FN816P	Washer (AN960-8L)	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5144757 ✓
				T117315-25 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-3A	5	187	0
	AN525-10R6	2	271	0
	AN525-832R7	2	103	0
	CB200	1	12	0
	D3802-1	2	38	0
	D4435-9	2	7	0
	D4436-041	1	0	0
	D4441-1	2	280	0
	D4730-020-030	1	10	0
	D4971-041	1	7	0
	D5076-041	1	3	0
	MS21042L06	7	110	0
	MS21042L08	2	966	0
	MS21042L3	5	2,066	0
	MS21059L3	2	98	0
	MS35206-229	7	95	0
	NAS1149F0332P	10	2,156	0
	NAS1149FN616P	14	471	0
	NAS1149FN816P	2	173	0

Part Specifications

Specifications could not be found.

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Machining ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Cross tube ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐		MRB (QSI042) ☐ ☐ ☐	
Date: _____		Sequence #: _____		QTY Affected: _____			
Description Work Order Deviation		Disposition		Completed By			
Root Cause		FAULT CATEGORY		QC / QA Coordinator			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				Lead hand / Supervisor			
				QC / QA Coordinator			

Change Record

PAGE 1 OF 1

Part Number: D350-567-145

Description: FLOOR WINDOW CLOSEOUT (AS350 B3e)

[illegible]

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	